

split
Work Order ID 69000-2

Wednesday, April 27, 2011 10:42:37 AM

Page 1

Item ID: D3912-041

Accept

Revision ID:

Item Name: Eyebolt Receiver Assembly

Setup Start

Stop

Start Date: 4/27/2011 Start Qty: ~~6.00~~

Required Date: 4/29/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 4-27-11

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3912

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

EF 11/06/13 ①

EF 11/06/13 ①

8 uloc 1/13

(X)

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Page 2

Item ID: D3912-041

Revision ID:

Item Name: Eyebolt Receiver Assembly

Start Date: 4/27/2011 Start Qty: 6.00

Required Date: 4/29/2011 Req'd Qty: 6.00

Reference:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: 507

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PCV/1/130

11/6/14

11-06-13
①

Picklist Print

Wednesday, April 27, 2011 10:42:43 AM

Page 1

Work Order ID: 69000

Parent Item: D3912-0411

Parent Item Name: Eyebolt Receiver Assembly



Start Date: 4/27/2011

Required Date: 4/29/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149C0663R

Purchased

No

Each

250.0000

6



Washer

Location

Loc Qty

Loc Code

ST297

250

110139

50

116893

200

D3912-1

Manufactured

No

100

Each

12.0000

1

6



Eyebolt

Location

Loc Qty

Loc Code

ST091

12

68380

12

D3912-3

Manufactured

No

100

Each

7.0000

2

12



Eyebolt Block

Location

Loc Qty

Loc Code

ST091

7

68378

7

4/27/06/13

6

4/27/06/13

B69539 (1X)

6

4/27/06/13

6

B68973 (4X)

Picklist Print

Wednesday, April 27, 2011 10:42:43 AM

Work Order ID: 69000

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 4/27/2011

Required Date: 4/29/2011

Start Qty: 6.00

Required Qty: 6.00

D3912-5 Manufactured No

100

Each

11.0000

2

12



Eyebolt Plate

Location

Loc Qty

Loc Code

ST091

11

B69001

66160

1

68381

10

Each

12.0000



EP 11/06/13

3
1
9
6

D3801-1 Manufactured No



Hand Retractable Spring Plunger

Location

Loc Qty

Loc Code

ST084

12

B69001

68379

12

Each

228.0000



EP 11/06/13

6
48

MS20615-4M20 Purchased No



RIVET

Location

Loc Qty

Loc Code

GA

228

117071

228

Each

55.0000



EP 11/06/12

48
6

MS21209-F615 Purchased No



Heli-Coil

Location

Loc Qty

Loc Code

ST305

55

108170

34

108244

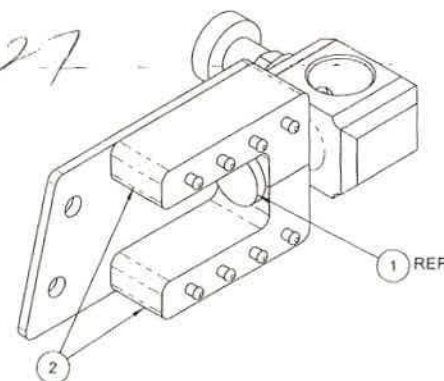
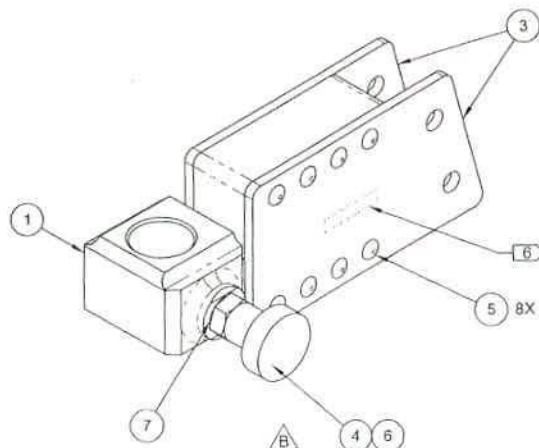
21



EP 11/06/13

6

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

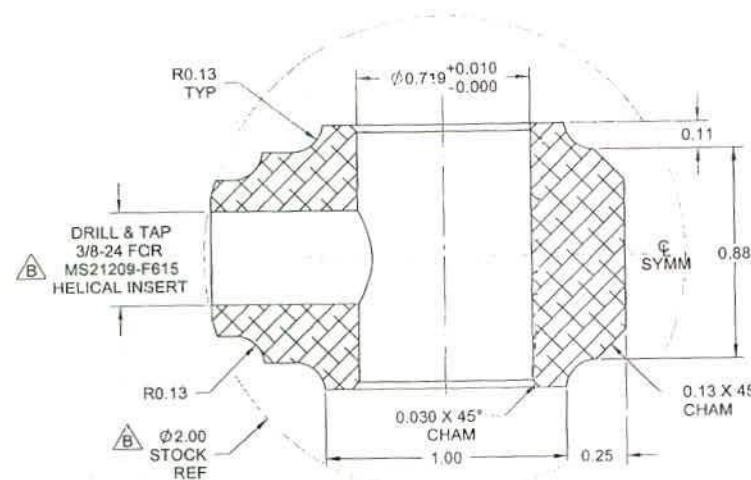
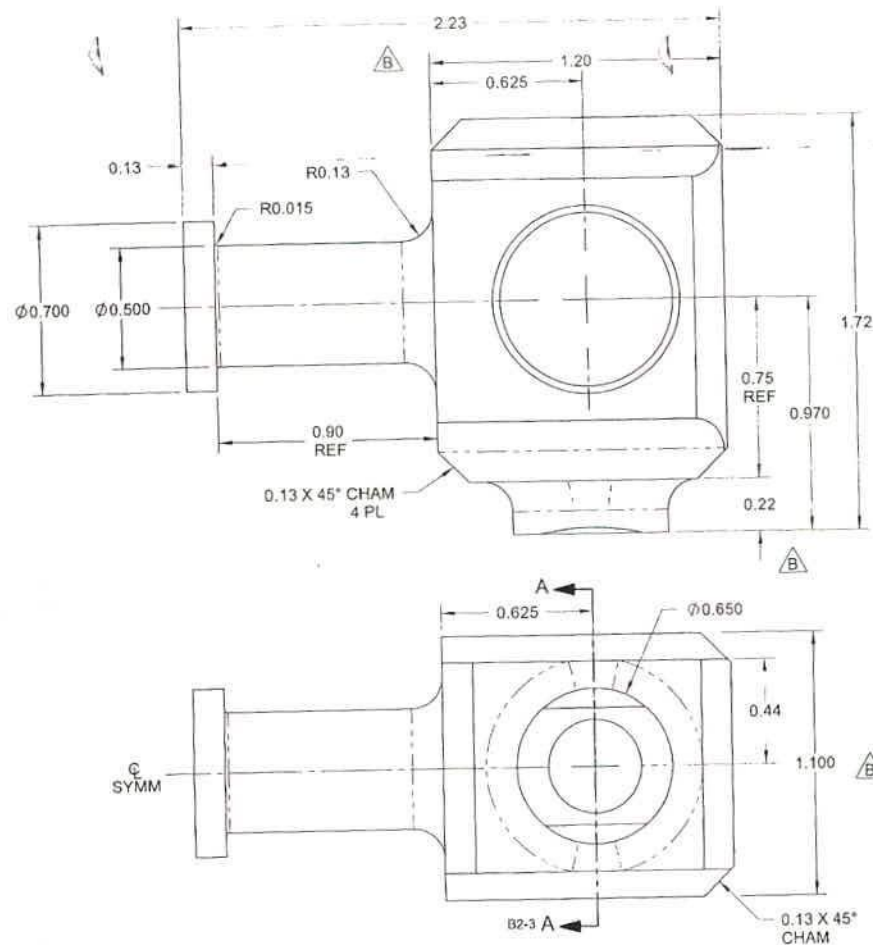
B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ASS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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RELEASED
2010-07-16



SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

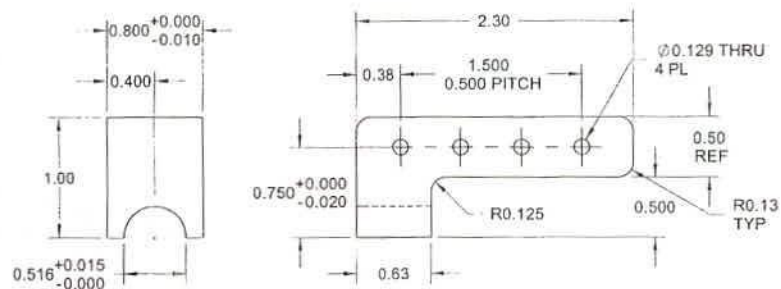
NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

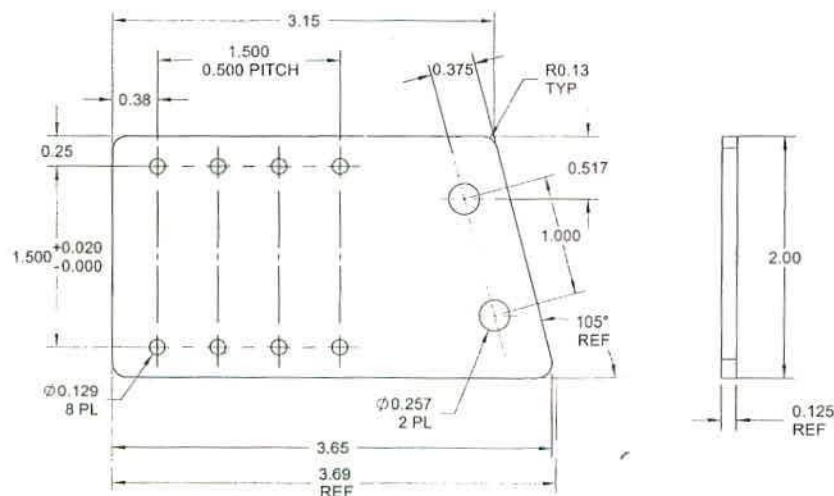
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CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3912	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	EYEBOLT RECEIVER ASSY	
DATE	10.06.28	NTS	

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u/o 69000



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

u6 49000

RELEASED
2010-07-16
mp

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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DE APPR.		EYEBOLT RECEIVER ASSY	NTS
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